

24

Date: Friday, 5/25/2007 8:05:14 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B STEP ASSEMBLY
Job Number	: 32557		
Estimate Number	: 10849		
P.O. Number	: <u>N/A</u>	Part Number	: D206628011
This Issue	: 5/25/2007 S.O. No. : <u>N/A</u>	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 30803	Material	: <u>N/A</u>
Written By	:	Due Date	: 6/12/2007 Qty: 3 Um: Each
Checked & Approved By	: <u>07.05.28</u>		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-011 CHG 002

K-S 07.05.30 (3)

2.0	32557A	206B STEP ASSY, LH
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Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2721-041 B 32557A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27313	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-3 Mounting Lug B29281- ✓

5.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-7 Mounting Lug B29339 ✓

07/6/14 (B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 32557

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty Part # Description Batch

✓ 2 D2856-400 6.9" Abrasion Strip

B32020 ✓

7.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total : 1.6380 f(s)

Pick :

Qty Part # Description Batch

2 D2856-400 6.25" Abrasion Strip

B32020 ✓

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-041 LUG ASS,Y

B30997 - ✓

9.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-043 LUG ASS,Y

B30907 4X - B30998 2X - ✓

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt

M4072 - ✓

11.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-11A Bolt

M102280 - ✓

P 7/6/13 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/06/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:05:14 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 32557

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

M103962

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s) +1

Pick:

Qty Part Number

Description

Batch

12 AN960JD416

Washer

M103691

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

M102552

10/7/14 (3)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PACKAGING RESOURCE #1

16.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-011

Location:

PPP Rev: E

10/7/15 (3)

59

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

10/7/15

Job Completion



10/7/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

24

Date: Friday, 5/25/2007 8:05:26 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B STEP ASSY, LH
Job Number : 32557A	
Estimate Number : 11698	
P.O. Number : <i>N/A</i>	Part Number : D2721041
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2721 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 30803A	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/12/2007 Qty: 3 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:F As Per Ecn 766 06-01-06 JLM	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :								
1.0	D2622120C	Extrusion								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)</p> <table border="0"> <tr> <td>Qty</td> <td>Part #</td> <td>Description</td> <td>Batch:</td> </tr> <tr> <td>1</td> <td>D2622-120C</td> <td>Extrusion</td> <td><i>331984</i></td> </tr> </table> <p>Check Material for any Dents or Defects</p> <p style="text-align: right;"><i>LE. 07.06.13</i></p>			Qty	Part #	Description	Batch:	1	D2622-120C	Extrusion	<i>331984</i>
Qty	Part #	Description	Batch:							
1	D2622-120C	Extrusion	<i>331984</i>							
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1								
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p>Cut D2721-1 using D2622 extrusion as per Dwg D2721</p> <p>Deburr and bevel ends for welding</p> <p style="text-align: right;"><i>LE. 07.06.13</i></p>										
3.0	D2734	206 Step Endplate								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)</p> <p>206 Step Endplate</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2734</td> <td>End Cap</td> <td><i>30883</i></td> </tr> </table> <p style="text-align: right;"><i>LE. 07.06.13</i></p>			Qty	Part Number	Description	Batch	2	D2734	End Cap	<i>30883</i>
Qty	Part Number	Description	Batch							
2	D2734	End Cap	<i>30883</i>							
4.0	D34611	PLATE								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)</p> <p>206 Step Lug</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D3461-1</td> <td>Plate</td> <td><i>329612</i></td> </tr> </table> <p style="text-align: right;"><i>LE. 07.06.13</i></p>			Qty	Part Number	Description	Batch	1	D3461-1	Plate	<i>329612</i>
Qty	Part Number	Description	Batch							
1	D3461-1	Plate	<i>329612</i>							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Friday, 5/25/2007 8:05:26 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 32557A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-3	Plate

Batch

329611

*SE 07.06.13*

3

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-5	Plate

Batch

329614

*SE 07.06.13*

3

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-7	Plate

Batch

329616

*SE 07.06.13*

3

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

*SE 07.06.14*

3

A/R AL Rod

Batch:

M104305  
M102756

*SE 07.06.14*

Grind end cap welds flush

*SE 07.06.14*

3

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*SE 07/06/14 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 32557A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

QC5

INSPECT WORK TO CURRENT STEP



*206-14 (3)*



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*KE 07.06.14*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*KE 07-06-14*

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod Batch: *M102756*

Grind End Cap Welds Flush

*KE 07.06.14*

*KE 07.06.14*

*KE 07.06.14*

*KE 07.06.14*

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/06/15 (2)*

15.0

QC5

INSPECT WORK TO CURRENT STEP



*206-15 (3)*



Comment: INSPECT WORK TO CURRENT STEP

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*(3X)*

Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

*M-L*

*07/06/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/06/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:05:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 32557A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

POWDER COATING

POWDER COATING



*m 104 144*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR/m-07-06-15 (3)*

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*fel 07/06/15 (3)*

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*m 104 281*



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

*fel 07/06/15 (3)*

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*fel 07/06/15 (3)*

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PPP B32557*

*fel 07/06/15 (3)*

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



*07/06/15 (3)*

Job Completion



*u 07-06-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

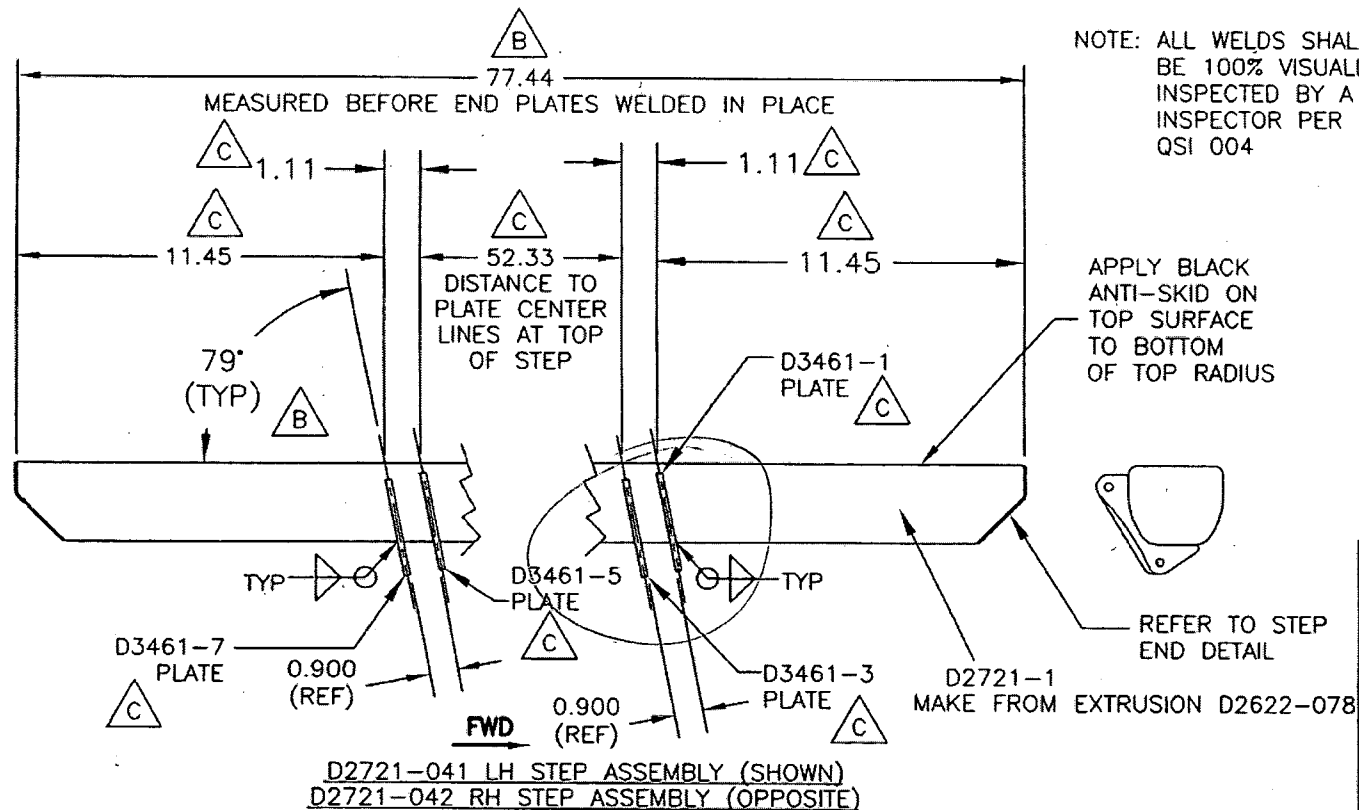
**NOTE:** Date & initial all entries

# DART

RELEASED  
05-11-14

# 05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

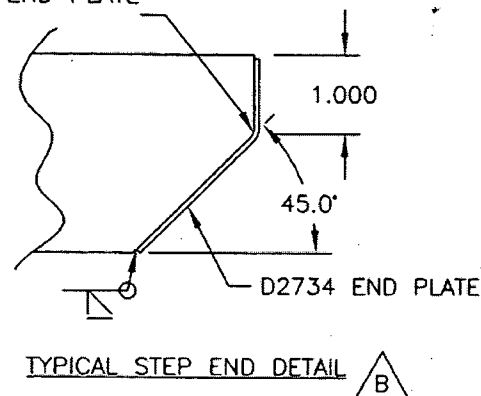


ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3287A



**D2721-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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